



Dart Aerospace Ltd.
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D4125-3**Job Sheet 195831****Part No:** D4125-3**Job Qty:** 4 pcs**Part Name:** Aft Sediment Bowl**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 5/31/19**Job Tracking No:****Due Date:** 6/17/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:**

Note: DWG REV E SHEET 2 IPP Rev:A 10.07.21 new issue DD verf:EC IPP Rev:B 11/12/05 as per rev.B JFS
verf:DD IPP REV:C 15.03.04 remove alodine and add holes DD VERF:JLM

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	4 pcs	6/17/19	6/17/19	0.00	1.19	Bandsaw - 1		<i>ML 19/06/19</i>
105	HAAS 5 Axis - B4B	4 pcs	6/17/19	6/17/19	0.26	9.52	HAAS - 5 - B4B		<i>ML 19/06/19</i>
110	QC 2	4 pcs	6/17/19	6/17/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		<i>ML 19/06/19</i>
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		

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Container No: S188830



Part: D4125-3

Job No: 195831

Serial No/Batch: S188830

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 06/10/19

				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
140	QC 8	4 pcs	6/17/19	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
150	Packaging 3-1 - Stock - B4B	4 pcs	6/17/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B

A- 19-06-12

JUN 1 2 2019

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				Packaging 3 - 29 - B4B				
				Packaging 3 - 30 - B4B				
				Packaging 3 - 31 - B4B				
				Packaging 3 - 32 - B4B				
				Packaging 3 - 33 - B4B				
				Packaging 3 - 34 - B4B				
				Packaging 3 - 35 - B4B				
				Packaging 3 - 36 - B4B				
160	QC 21 - SA	4 pcs	6/17/19	0.00 0.00	QC 21 - SA - 21	DAG		
					QC 21 - SA - 70	21		
					QC 21 - SA - 53	S-85		
Part Op 100 - (Bandsaw) 1-Cut Blank at 6.500" Descriptions: 105 - (HAAS CNC vertical machine #5) Machined as per folio FB079 110 - (QC2- Inspect parts off machine FAI/FAIB) 140 - (QC8- Inspect parts - second check) 150 - (Identify as per dwg & Stock Location: _____) LOCATION: WA003 160 - (QC21- Final Inspection - Work Order Release)								
JUN 11 2019								
Job BOM								
Part / Item	Component Name	Quantity	Operation	Container				
M6061T6B2.000X08.000	6061-T6 Bar 2.00' X 8.00" (Cut In 4Ft Section)	2.1680 ft (.542 ea)	100-Bandsaw - 1	S110 497				
Job Allocations								
Operation	Component Part	Required	Inventory	Allocated				
100-Bandsaw - 1	M6061T6B2.000X08.000	2	11	0				
Part Specifications								
Specifications could not be found.								

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DART AEROSPACE LTD		Work Order: 195831
Description: Aft Sediment Bowl		Part Number: D4125-3
Inspection Dwg: D4125	Rev: D E DEF 19/05/31	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.26	+/-0.030	0.260	/		Vern HI-08	
0.19	+/-0.030	0.190	/			
0.20	+/-0.030	0.200	/			
0.25	+/-0.030	0.250	/			
0.43	+/-0.030	0.425	/			
1.95	+/-0.030	1.949	/			
2.599	+/-0.005	2.600	/			
Ø0.257	+0.006/-0.001	Ø0.258	/			
0.06	+/-0.030	0.082	/			
6.22	+/-0.030	6.214	/			
6.00	+/-0.030	6.000	/			
5.23	+/-0.030	5.230	/			
0.06	+/-0.030	0.083	/			
1.36	+/-0.030	1.380	/			
2.47	+/-0.030	2.470	/			
Ø0.348	+0.006/-0.001	Ø0.347	/			
0.30	+/-0.030	0.300	/		R-G Reb Vern HI-08	
R0.19	+/-0.030	R.190	/			
2.86	+/-0.030"	2.860	/			
0.25	+/-0.030"	0.250	/		1	
0.25	+/-0.030"	0.250	/			

Measured by: DEF	Checked by: B.F	QC Inspector:
Date: 19/06/10	Date: 19-06-12	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	12.07.31	New Issue	KJ	
B	15.11.03	Dimensions updated per Dwg Rev D	KJ	
C	17.07.13	Dimensions updated per Dwg Rev E	KJ	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					